

Date: Friday, 28/11/2008 3:05:22 PM  
 User: Julie Dawson

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: STEP LEG		
Job Number	: 43858C			Part Number	: D30655		
Estimate Number	: 10382			Drawing Number	: D3065 REV. B		
P.O. Number	:			Project Number	: N/A		
This Issue	28/11/2008	S.O. No.	:	Drawing Revision	: B		
Prsht Rev.	: NC			Material	:		
First Issue	28/11/2008	Type	: SMALL /MED FAB	Due Date	20/12/2008	Qty:	100
Previous Run	: 42344C			Um:	Each		
Written By	:						
Checked & Approved By	: <u>JUL 08.12.01</u>						
Comment	: Est:C 02.11.01 Incorporated D3066-1 IPP KJ/RF Est Rev:D Now on Water Jet 06-04-11 JLM Est Rev:E Now manufactured with 6061-T6 06-05-25 JLM						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6S080	6061-T6 .080 Sheet	
		Comment: Qty.: 1.1338 sf(s)/Unit Total : 113.3790 sf(s) Material: 6061-T6 0.080" thick (M6061T6S.080)	Batch: <u>10254</u> B 8-12-29
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D Dwg Rev: <u>B</u> Prog Rev: <u>B</u>	<u>B 8-12-29</u>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<u>B 8-12-29</u>
4.0	QC8	SECOND CHECK	 <u>108.12.30</u>
		Comment: SECOND CHECK	 <u>108.12.30</u>
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	 <u>Awm 9-01-06</u> <u>108</u>
		Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1	 <u>108</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3065-5 PAR #: N/A Fault Category: Pcoll/Med & Small NCR: Yes No DQA: A Date: 09/11/07  
D3065-041-D350-571-31/132/1213/214 CWT Resolution: SCRAP Disposition: SCRAP QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08-12-30	Q-0	2 parts scrap. Holes are out of alignment due to the material lifting: Shifting. 0.030? R.C: process.	QSIU42	Scrap & destroy QSIU2 No replace	B 8-12-30	08-12-30	08-12-30	08-12-30

NOTE: Date & initial all entries

Date: Friday, 28/11/2008 3:05:22 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP LEG

Job Number: 43858C

Part Number: D30655

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

*E09/01/07* 108

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: *G-A*

*E09/01/07* 108

8.0 QC21

FINAL INSPECTION/W/O RELEASE



108

Comment: FINAL INSPECTION/W/O RELEASE

*E09/01/07*

Job Completion



*U 09/01/07*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	H3858C
Description: Step Leg	Part Number:	D3065-5
Inspection Dwg: D3065	Rev: B	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

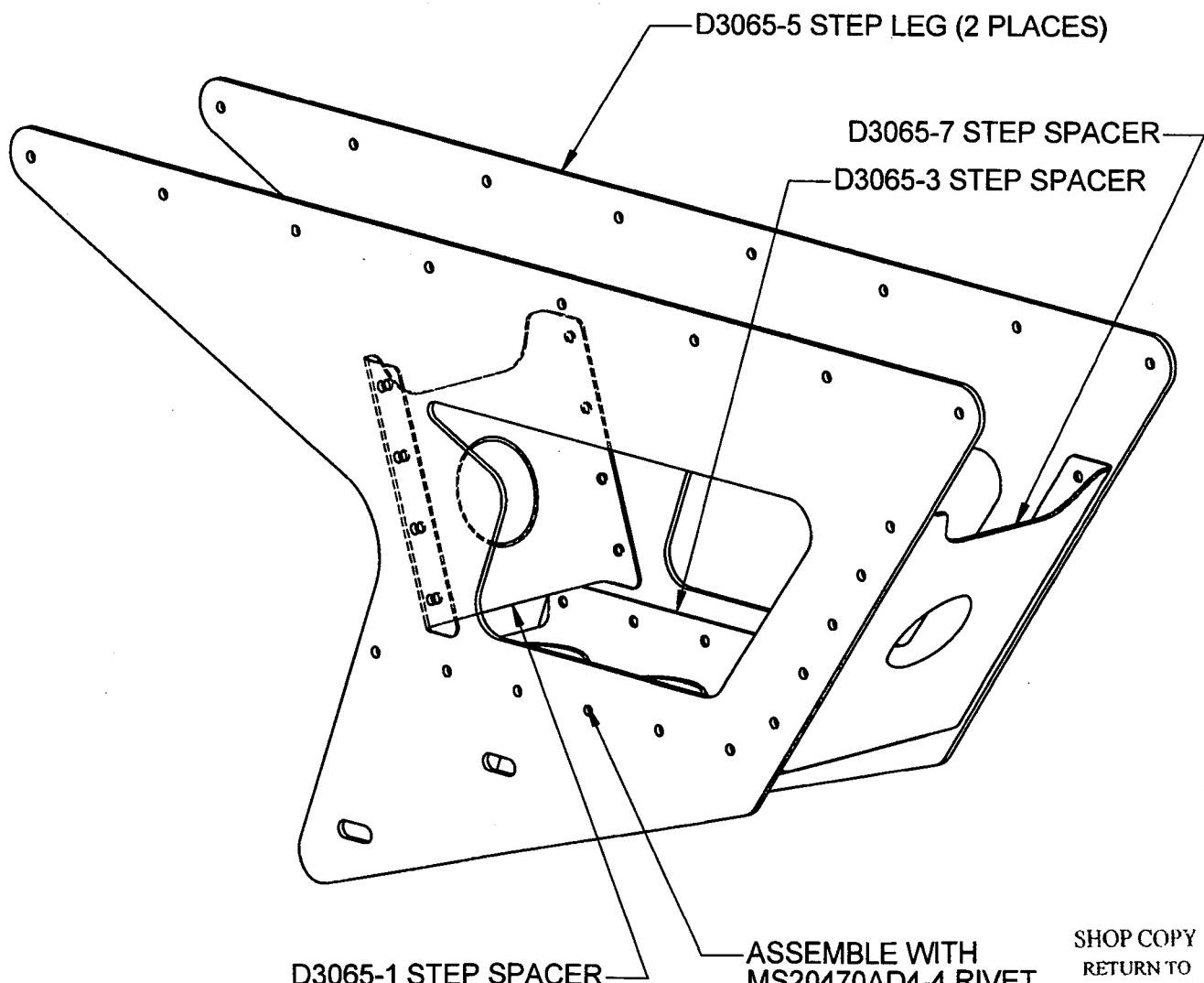
## **X** First Article      **□** Prototype

Measured by:	<u>B</u>	Audited by:		Prototype Approval:	N/A
Date:	<u>8-14-29</u>	Date:		Date:	N/A

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A	03.09.22	New Issue P/O D3065-041	KJ/RF	
B	04.06.15	Added Ø0.128 dimension	KJ/JLM	
C	06.06.23	Dwg Rev. changed	KJ/JLM	gj

**DART**

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B	SHEET 1 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:2	
A	02.09.11	NEW ISSUE		
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5		

**RELEASED***06.06.20 [Signature]***D3065-041 STEP LEG ASSEMBLY**

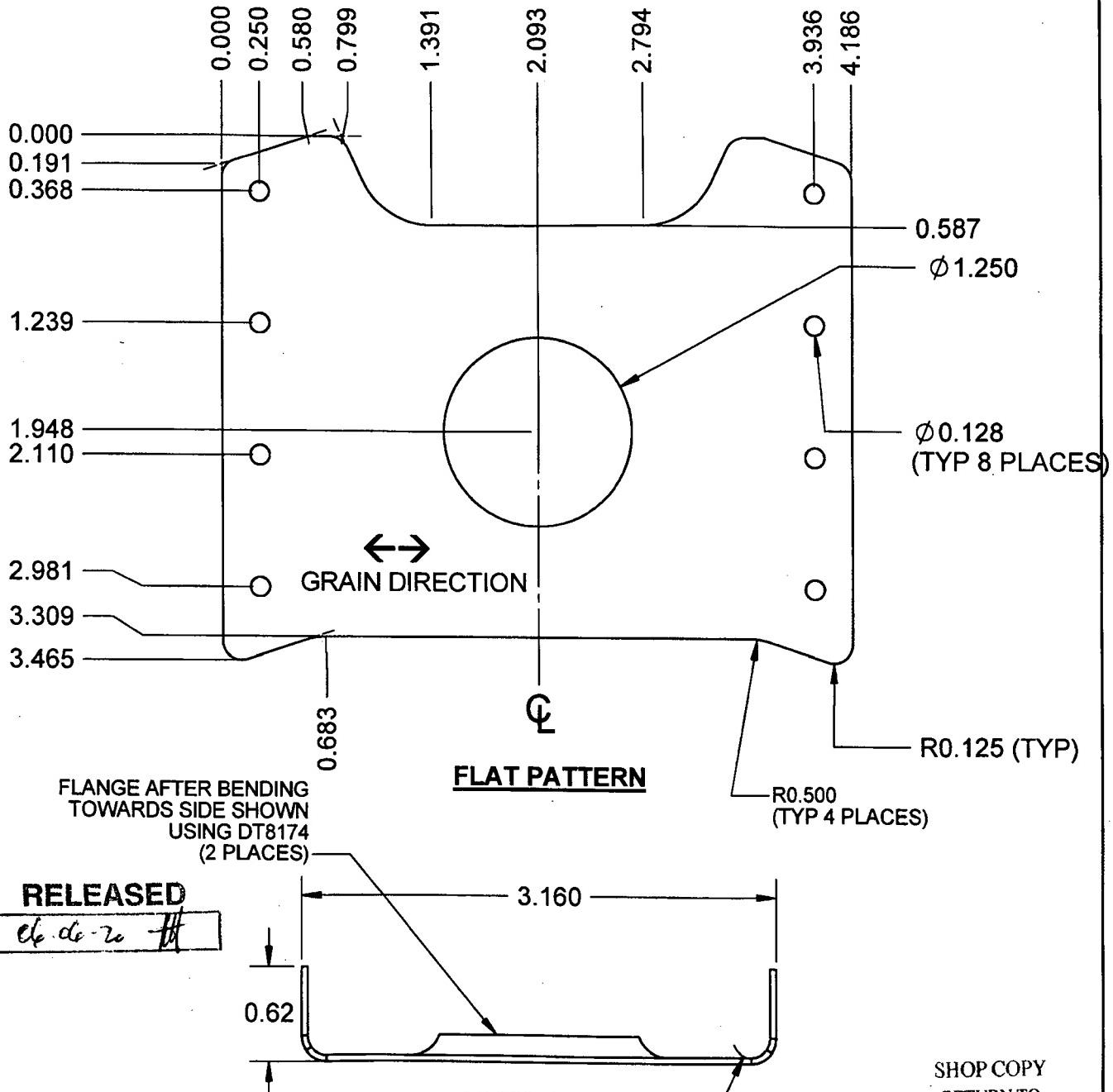
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WORK ORDER  
NO. *43858*

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CHECKED <i>PH</i>	APPROVED <i>MM</i>	DRAWING NO. D3065	REV. B	SHEET 2 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1	

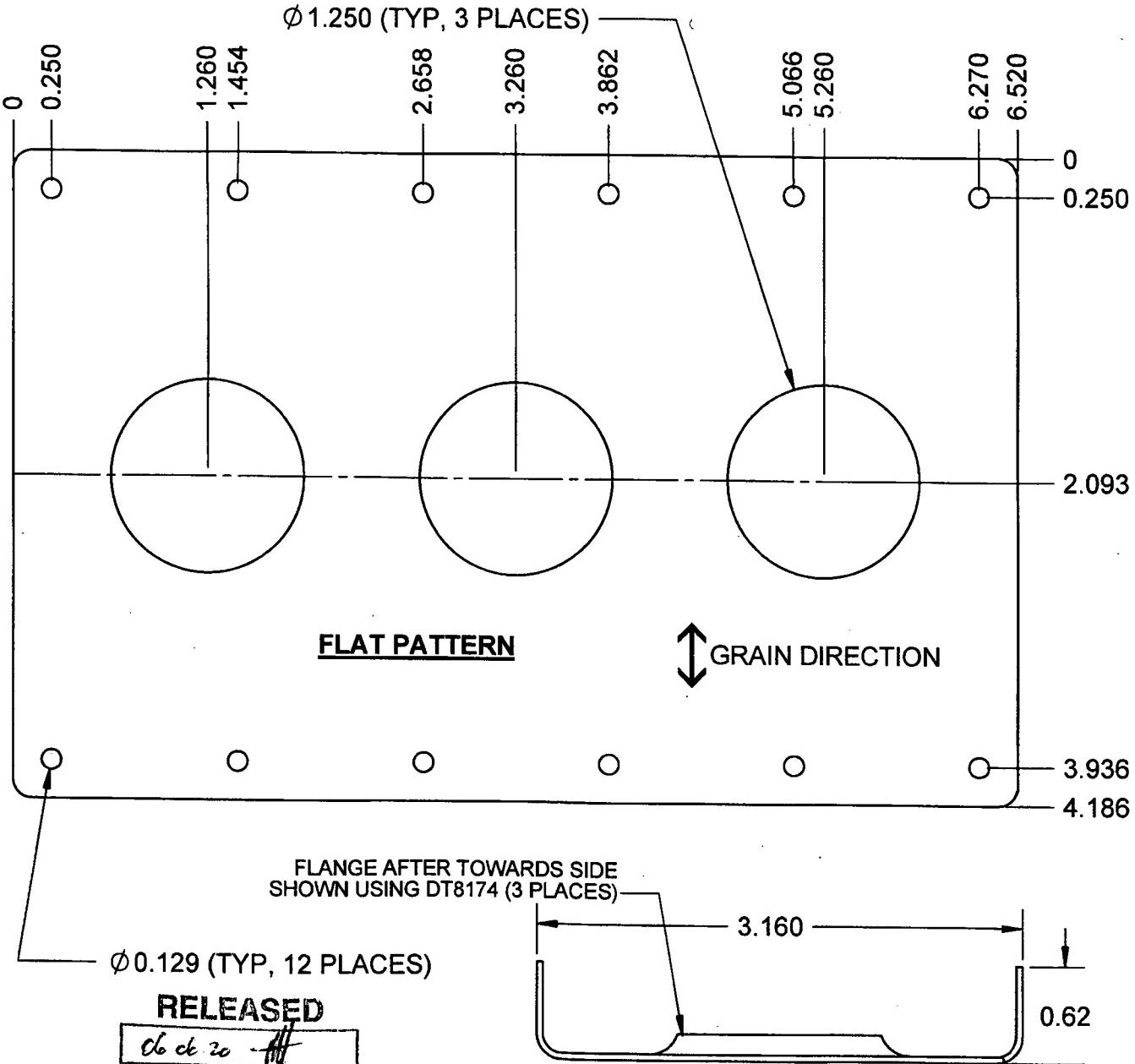
**D3065-1 STEP SPACER**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1

**D3065-3 STEP SPACER**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4)  
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

R0.125  
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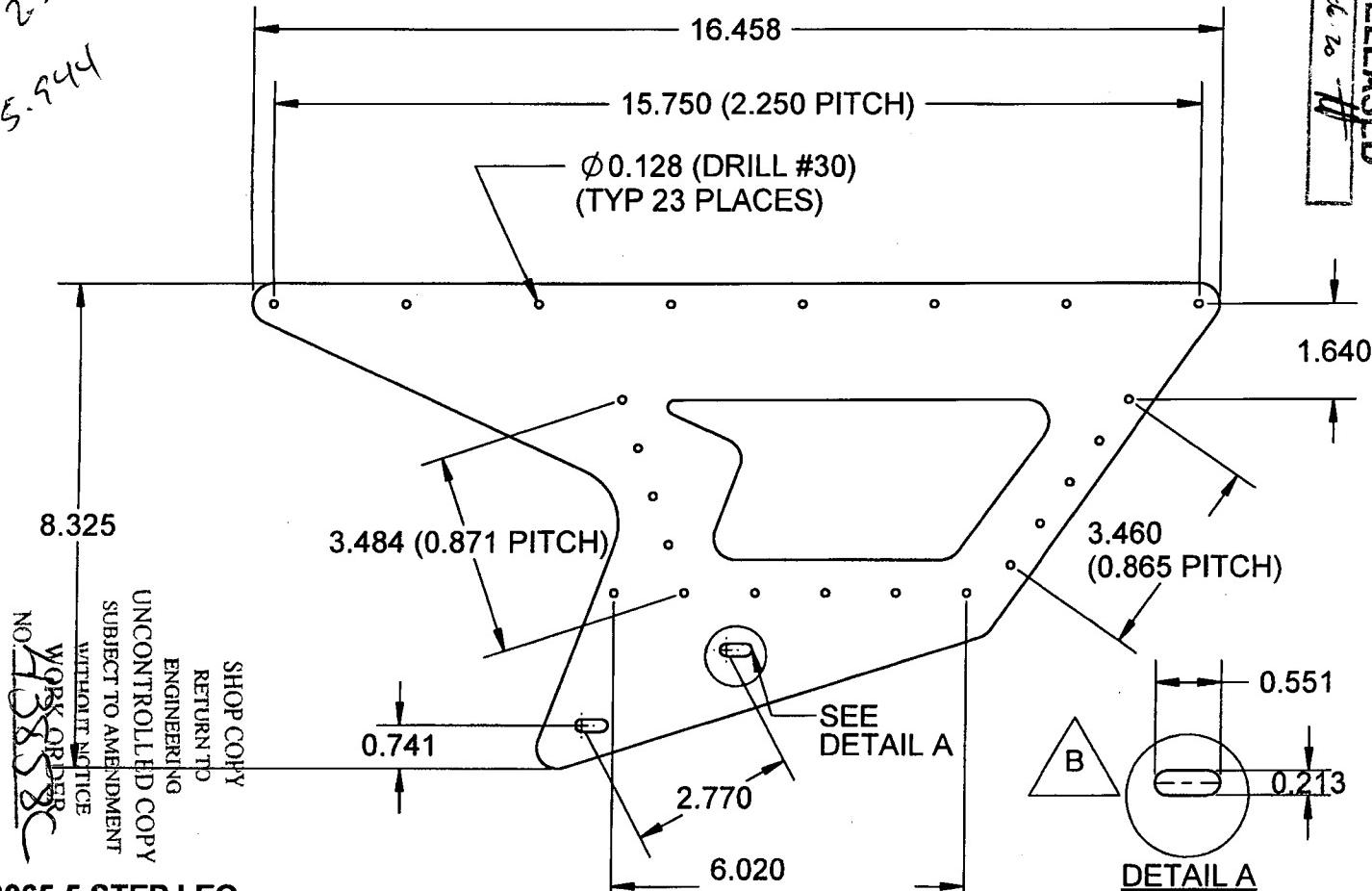
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APPROVED	P.H.	DRAWING NO.	D3065
DATE	06.05.23	TITLE	STEP LEG ASSEMBLY

REV. B  
SHEET 4 OF 5  
SCALE 1:3

**RELEASED**  
06.06.20**D3065-5 STEP LEG**

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK  
(REF DART SPEC M6061T6S.080)  
OR  
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

**DART**

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CHECKED <i>PH</i>	APPROVED <i>MM</i>	DRAWING NO. D3065	REV. B SHEET 5 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1

